

Work Order ID 55743

January 29, 2010 8:28:43 AM



Page 1

Item ID: D2199-23

Accept



Setup Start



Revision ID:

Stop



Item Name: Strut Details

Start Date: 1/28/10 Start Qty: 4.00



Cust Item ID:

Required Date: 2/08/10 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: *[Signature]*

Date: 10-1-29

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2199	Rev E1								

100

0.00



NC BRAKE

Brake NC

Memo

0.00

Brake NC

Punch per Dwg D2199 and Spec Control Dwg D2638

SD 10/02/02

4 18

110

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

Deburr

10/02/03 *[Signature]*

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

SD 10/02/03

(24)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Stop

QC: Date: SPC (Y/N): Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

130

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME: 7:10AM OVEN TEMPERATURE:
7:40AM FINISH TIME: 400°F

M113170

7 10-02-04

(4)

Ø

140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

10-02-04 (4)

150

Identify as per dwg & Stock Location 264

0.00



Packaging

Memo

0.00

Packaging

10-02-08 (4) SP

W/O:		WORK ORDER CHANGES					
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Cust Item ID:

Required Date: 2/08/10 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00

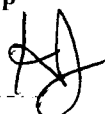


QC

Memo

0.00

Quality Control

10/02/09 
MF
10-2-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Picklist Print

January 29, 2010 8:28:47 AM

Page 1

Work Order ID: 55743



Parent Item: D2199-23



Parent Item Name: Strut Details

Start Date: 1/28/10

Required Date: 2/08/10

Comments: IPP: ☐D☐02.06.10☐Rem polish & add finish☐NG/CC

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304TR0.750W.049		Purchased	No			100	f	277.2810	9.2632			



304 RD Tube .750 x .049W

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	277.281	
107518	2.77	
108498	0	
109314	8.5	
110113	0.73	
110271	0.03	
111096	9	
111457	11.43	
112652	44.89	
112800	199.931	

10.5

8810102102 (4)

W/O:		WORK ORDER CHANGES					
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DART

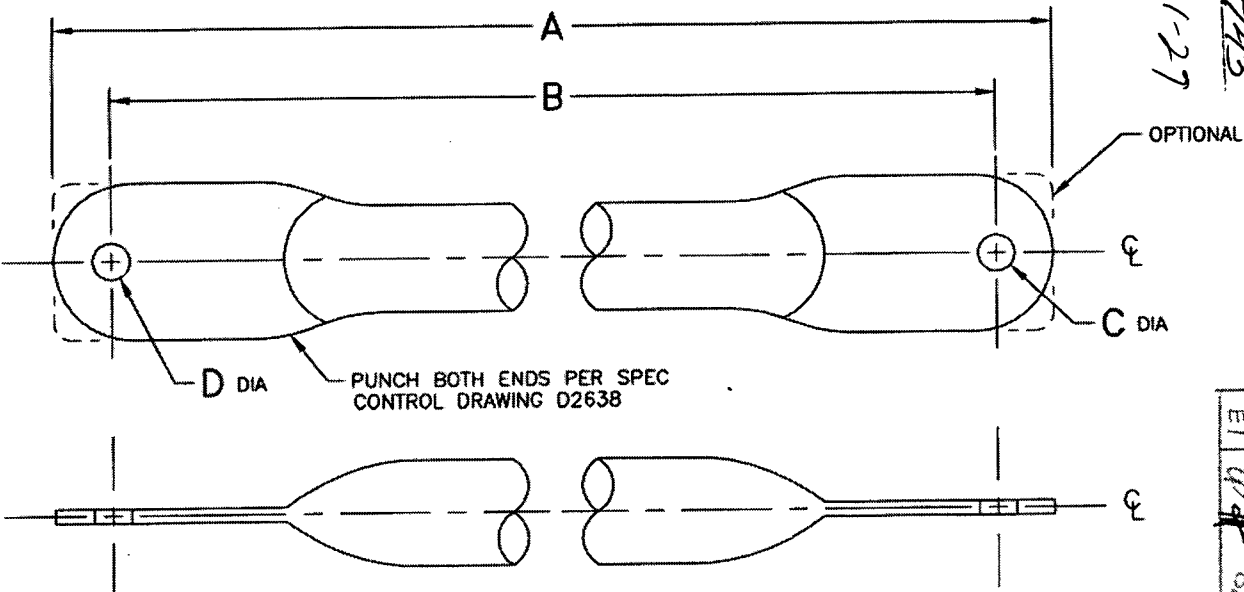


DESIGN	DRAWN BY	DART AEROSPACE LTD	
CHECKED	APPROVED	DRAWING NO.	HAWKESBURY, ONTARIO, CANADA
DATE		TITLE	REV. E
98.04.28		STRUT DETAILS	SHEET 1 OF 1
			SCALE
			NTS

RELEASED
11/18/05
4E

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 55743

AL 10-1-27



	A	B	C	D
D2199-1	18.30	17.50	0.257	0.257
D2199-3	5.80	5.00	0.257	0.257
D2199-5	22.64	21.84	0.257	0.316
D2199-7	14.74	13.94	0.257	0.257
D2199-9	16.52	15.72	0.257	0.257
D2199-11	23.60	22.80	0.257	0.316
D2199-13	15.96	15.16	0.257	0.257
D2199-15	17.57	16.77	0.257	0.257
D2199-17	28.05	27.25	0.257	0.316
D2199-19	18.90	18.10	0.257	0.257
D2199-21	10.80	10.00	0.257	0.257
D2199-23	26.18	25.38	0.257	0.316
D2199-25	19.93	19.13	0.257	0.257
D2199-27	27.34	26.54	0.257	0.316
D2199-29	21.11	20.31	0.257	0.257

B
B
B
C
C
C
D
D
E
E

100.10.13
100.10.13

NOTES:

1. MAKE PER TEMPLATE DT2199-XX WHERE XX IS THE RESPECTIVE DASH NUMBER
2. MATERIAL: AISI 304/316 STAINLESS STEEL TUBE $\phi 0.750 \times 0.049$ WALL
3. FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3 **EI**

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